

Work Order ID 133563

Wednesday, June 10, 2015 12:45:35 PM

133563

Page 1

Item ID: D5051-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cyclic Switch Housing Assembly
 Start Date: 6/10/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/10/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: ML3 Date: JUN 10 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5051	C								

100 0.00
100
 Purchasing Memo 0.00
 Purchasing ISSUE PO: P/O: 29013
 TO: RED BARN
 C OF C IS REQUIRED

CY JUL 02 2015 10

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging

CY 15/08/17 10

115 QC5- Inspect part completeness to step on W/O 0.00
115
 QC Memo 0.00
 Quality Control

(10) 10
 DAS 38
 AUG 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																					
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Work Order ID 133563***133563***

Page 2

Item ID: D5051-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cyclic Switch Housing Assembly

Start Date: 6/10/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/10/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: 5144

0.00

120

Packaging

Memo

0.00

Packaging

10

27

9-89

AUG 28 2015

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCS

AUG 28 2015

JH

20150828

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Wednesday, June 10, 2015 12:45:39 PM

Page 1

133563

D5051-041

Required Date: 6/10/2015

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 15.02.24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5051-041P		Purchased	No				Each	0.0000		10			
D5051-041P									**	C215108117			
Cyclic Switch Housing Assembly													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

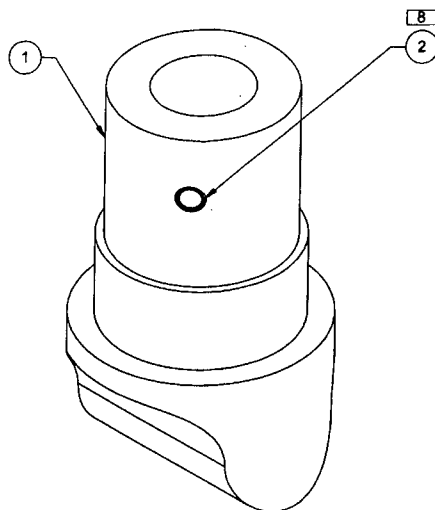
QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

ITEM	QTY	P/N	DESCRIPTION
	X	D5051-041	CYCLIC SWITCH HOUSING ASSY
1	1	D5051-1	CYCLIC SWITCH HOUSING
2	1	MS21209C0810	HELICOIL



D5051-041 CYCLIC SWITCH HOUSING ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133563 MLJ
15-06-10

RELEASED

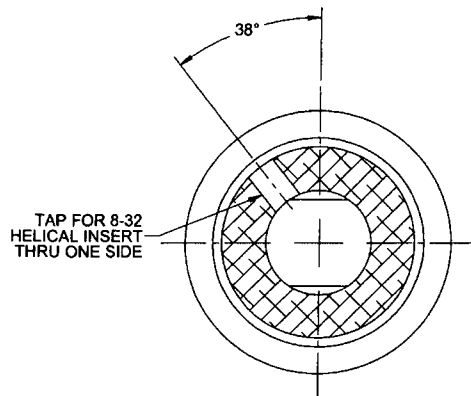
2015 FEB 23
ECN 15-523 4

NOTES:

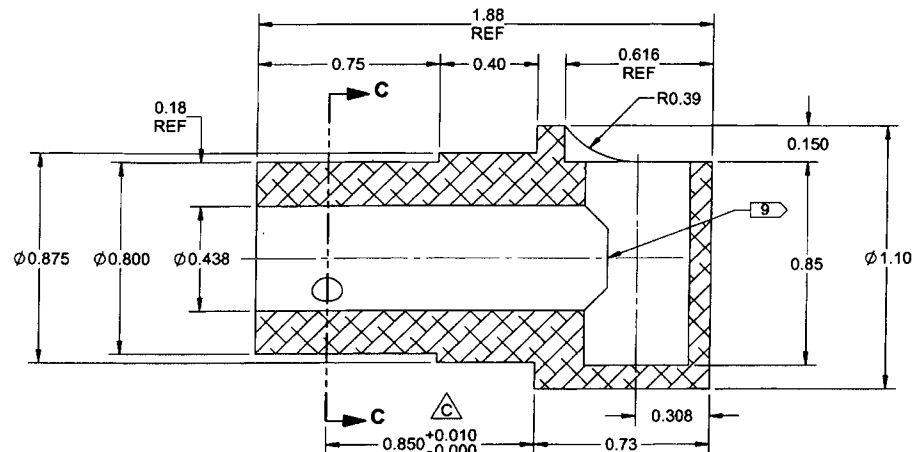
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5051-041" AND B/N BXXXXX USING A MARKED BAG PER QSI 044 6.7
- 7) WEIGHT: 0.07 lbs
- 8) INSTALL HELICOIL AFTER FINISH

C	ADDED BOM (ZN 07-1), ADDED D5051-041 (ZNBS-1), ADDED NOTE 8 (ZN AB-1), ADDED SHEET 2, REVISED HOLE POSITION (ZN C3-2), REF NCR15-4575.	AK	15.02.04
B	REDESIGNED BASED ON TCCA PILOT FEEDBACK AND TO INCORPORATE SMALLER SWITCH.	ML	14.06.24
A	NEW ISSUE	ML	14.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5051	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CYCLIC SWITCH HOUSING	NTS
DATE	15.02.04	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

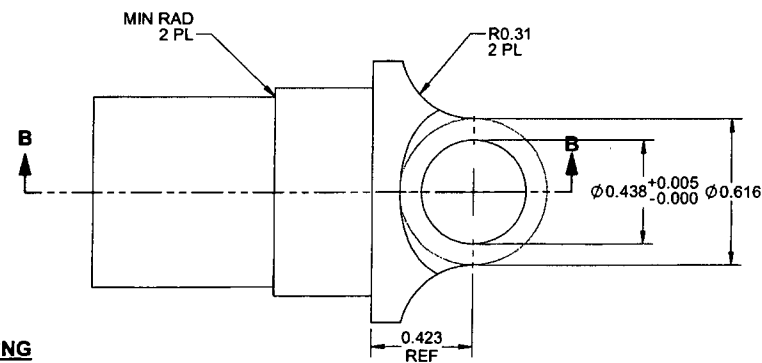
APPROVED



SECTION C-C



SECTION B-B



D5051-1 CYCLIC SWITCH HOUSING

RELEASED

2015 FEB 23

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8
OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221, REF DART SPEC M6061T6R
OR: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8
OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221, REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625, TYPE II, CLASS II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs
- 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5051-1-REVC.STP"
- 9) BREAKTHROUGH IS CREATED, DEBURR ALL INTERNAL/EXTERNAL SHARP EDGES

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5051	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CYCLIC SWITCH HOUSING	NTS
DATE	15.02.04	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART
SPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER**Purchase Order ID PO29013**

Purchase Order Date 7/2/2015 1:26:29 PM
PO Print Date 8/17/2015

Page Number 1 of 3

Order From :
RED BARN MACHINE INC.
190 S DANEBO AVE.
EUGENE, OR 97402
USA

VU-RED001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name
Vendor Phone 541-344-9953

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4983-041P	Cargo Hook Assembly	8/21/2015 Yes 8/21/2015	FN	10.00 Each	\$1,500.00	\$15,000.00

AS PER DWG D4983 REV. F
B133553,B133554,B133555,B133556,B133557,B133558,B133559,B133560,B133561,B133562

8/15-08-17

2 D5051-041P Cyclic Switch Housing Assembly

8/21/2015 FN
Yes
8/21/2015

10.00
Each

Line Total: \$15,000.00

\$300.00 \$3,000.00

AS PER DWG D5051 REV. C
B133563

*8/15/08/17**8/15-08-17***Line Total:** \$3,000.00**Note:**

8/17/2015



Pack Slip: 18559
18559

Packing Slip

Page: 1 of 1

Ship To:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ONTARIO K6A 1K7
CANADA

Phone: 800-556-4166
Fax: 714-755-2995

Sold To:

CHANTAL LAVOIE
DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ONTARIO K6A 1K7
CANADA

Phone: 800-556-4166
Fax: 613-632-4443
dkennedy@dartaero.com

Ship Date: 8/14/2015

Ship Via: FEDEX P1 COLLECT

F.O.B.: EUGENE, OR

Order: 16618

PO: 29013

Salesperson: ERIC BACON

DARTACCT

PO	Line	Planned Qty	Shipped Qty	Part Number/Description	Rev
		10.00	10.00 <i>spz</i>	D4983-041P	F
		10.00	10.00 <i>spz</i>	CARGO HOOK ASSEMBLY D5051-041P	
		10.00	10.00 <i>spz</i>	CYCLIC SWITCH HOUSING ASSEMBLY D5066-3P	
		10.00	10.00 <i>spz</i>	CARGO HOOK PLACARDS D5066-5P	
		10.00	10.00 <i>spz</i>	CARGO HOOK PLACARDS D5066-7P	
		10.00	10.00 <i>spz</i>	CARGO HOOK PLACARDS D5066-9P	
		10.00	10.00 <i>spz</i>	CARGO HOOK PLACARDS D5066-9P	

Dart Aerospace hereby certifies that all materials used in the manufacturing of our tools are new and meets all specifications called out in all applicable blueprints and drawings. All standard machining and manufacturing procedures are strictly followed.

Brian H. H.
Signed

PackSlip:8.03:01

190 S. Danebo Avenue
Eugene, OR, USA 97402
dartaerospace.com

T 1 541 344-9953
F 1 541 344-3863

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E sales@dartaero.com

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Certificate of Conformance

Customer: DART Aerospace LTD. (Hawkesbury)

Purchase Order: 29013

Part Number	Description	Quantity	Batch
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-11
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-12
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-13
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-14
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-15
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-16
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-17
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-18
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-19
D5051-041P	Cyclic Switch Housing Assembly	1	01-16263-20

Packing Slip Number: 18559

SP 15-08-17

ALL MATERIALS, PARTS, COMPONENTS HAVE BEEN INSPECTED AND HAVE BEEN MANUFACTURED TO THE DRAWINGS LISTED ON :

D5051 Rev. C

Date of MFG 5-16-2015

Approved By:

Date: 8-10-2015

Quality Assurance Manager

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